

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023486**Date Inspected:** 10-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Steve McConnell**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI was present to observed welding of the full size Electro-Slag Welding (ESW) weld trial (mock up). The QAI met with the Quality Control Inspector (QCI) Steve McConnell, the Caltrans QAI Jeff Smith and discussed the operations that will be performed. The QAI Jeff Smith was informed that the fit-up measurements were recorded and according to previously reported events, the contractor has ground a 6mm offset into the top of the mock up. The QAIs were informed that in addition to the induced planar offset, the contractor will use several layers of insulating fiber to induce a larger shoe / weld cover in a section of the weld trial. The QAI noted that fit-up and equipment set-up operations were in progress until approximately 1300 hours and that the ESW was started and stabilized at 1312 hours. The QAI witnessed the contractor performing the ESW weld and noted that there appears to be general coordination with the process of jumping the cooling shoes. The QAI was informed that the welding parameters are being recorded on a data logger. The QAI was not able to make independent readings of the welding parameters. The QAI noted that the QAI Jeff Smith is monitoring the welding until completion. The work was in progress at the end of the shift. See the attached photos.

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---



## Summary of Conversations:

The QAI relayed the status of the ESW mock up to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Croff, Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

---